

Date: Monday, 12/05/2008 10:02:13 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	OUTER AFT SADDLE
Job Number :	39198		
Estimate Number :	11080		
P.O. Number :		Part Number :	D5955
This Issue :	12/05/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D5955 REV B
First Issue :	/ /	Project Number :	N/A
Previous Run :	38690	Drawing Revision :	B
	Type :	Material :	
	MACHINED PARTS	Due Date :	05/06/2008
Written By :		Qty:	8 Um: Each
Checked & Approved By :	<u>JUL 08-5-12</u>		
Comment :	Est Rev:E Re-Format 05-11-29 JLM Est Rev:F ecn826 06.12.06 ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101013	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)
 D6101-013 (7075-T7351)
 Size 2.50" x 10.10" X 8.25" (Grain along 10.10")
 Batch: B38696

DJP 08/05/29

2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3
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P10 =>

Comment: HAAS CNC VERTICAL MACHINING #3

1-Machine as per folio D5955, Ensure Batch Number is entered

2-Machine Keyway

3-Deburr & Tumble

DJP 08/05/29 / 2F 08/05/31

3.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

DJP 08/05/29 2F 08/05/31

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

JL 08/06/01

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

M-H / 08/06/02

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/05/2008 10:02:13 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTER AFT SADDLE

Job Number: 39198

Part Number: D5955

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M/07925



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

1:05

OVEN TEMPERATURE:

320°

FINISH TIME:

1:35

FL 08/06/02

(8)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BK 08-06-02

(8)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 421

8/6/02 (8x) SD

(8x)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

PD 08/06/03

Job Completion



u 8-06-03

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D5955 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR: <u>39198</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.05.30	2	CHAMFER TO B16 ON SKID BOLT EDGE by 1050" OVER TOL. SPARTS	CP 08.05.30 per Q51042	Parts acceptable Qty x <u> </u>	DJP 08/05/30	S 08/05/30	CP 08.05.30 per Q51042	S 08/05/30

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 39198
Description: Outer Aft Saddle		Part Number: D5955
Inspection Dwg: D5955	Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.442	0.443	0.443	0.443		
B	1.745	1.755		1.746	1.749	1.749	1.750		
C	5.245	5.255		5.2485	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.749	4.749	4.750	4.750		
G	0.315	0.322		0.316	0.316	0.316	0.316		
H	1.522	1.532		1.528	1.528	1.527	1.527		
I	3.048	3.058		3.054	3.054	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.313	0.318		0.316	0.316	0.316	0.316		
L	0.495	0.505		0.500	0.500	0.500	0.500		
M	0.490	0.510		0.4955	0.495	0.4955	0.500		
N	1.865	1.885		1.873	1.877	1.877	1.877		
O	7.990	8.010		7.997	8.000	7.998	7.998		
P	2.240	2.260		2.246	2.2495	2.250	2.250		
Q	0.307	0.312		0.310	.310	.310	.310		
R	0.760	0.765		0.760	.766	.760	.760		
S	0.490	0.510		0.498	0.5015	0.501	0.498		
T	1.625	1.645		1.635	1.6345	1.635	1.6355		
U	2.000	2.020		2.007	2.005	2.006	2.006		
V	0.023	0.043		0.033	.033	.033	.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									

Accept/Reject

Measured by: DJP	28
Date: 08/05/23	08/05/21

Audited by: J.L.
Date: 08/06/01

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	

DART AEROSPACE LTD		Work Order:	39198
Description: Outer Aft Saddle		Part Number:	D5955
Inspection Dwg: D5955	Rev: B	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5	6	7	8		
A	0.438	0.443		0.443	0.443	0.443	0.443		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.001	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.749	4.750	4.7485	4.749		
G	0.315	0.322		0.316	0.316	0.316	0.316		
H	1.522	1.532		1.528	1.527	1.528	1.528		
I	3.048	3.058		3.054	3.053	3.054	3.054		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.313	0.318		0.316	0.316	0.316	0.316		
L	0.495	0.505		0.500	0.500	0.500	0.500		
M	0.490	0.510		0.499	0.500	0.5005	0.500		
N	1.865	1.885		1.875	1.875	1.875	1.874		
O	7.990	8.010		7.998	7.995	7.995	7.991		
P	2.240	2.260		2.249	2.251	2.250	2.250		
Q	0.307	0.312		0.310	0.310	0.310	0.310		
R	0.760	0.765		0.760	0.760	0.760	0.760		
S	0.490	0.510		0.5005	0.500	0.500	0.500		
T	1.625	1.645		1.6355	1.636	1.636	1.638		
U	2.000	2.020		2.008	2.0095	2.0075	2.006		
V	0.023	0.043		0.033	0.033	0.033	0.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									

Accept/Reject

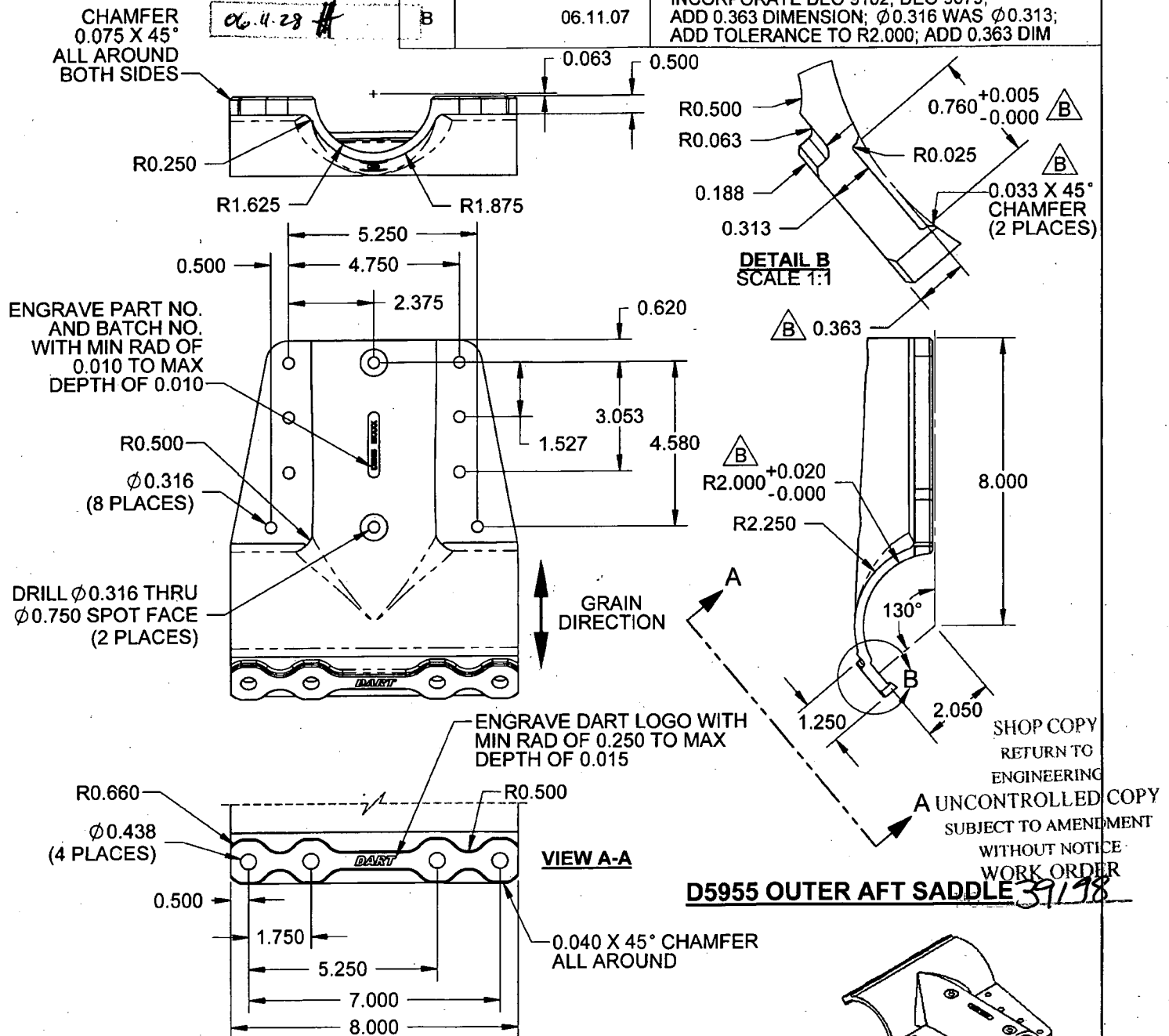
Measured by:	DJP
Date:	08/05/30

Audited by:	JL
Date:	08/06/01

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D5955	REV. B SHEET 1 OF 1
DATE 06.11.07	TITLE OUTER AFT SADDLE		SCALE 1:4
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE	
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-013 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3 ΔB
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

ISOMETRIC VIEW
SCALE 1:8

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